

## ABSTRACT OF THE DISCLOSURE

An improved pipe belling process is shown which a gasket is installed on the outer working surface of a forming mandrel at one circumferential location. The heated socket end of a thermoplastic pipe is forced over the mandrel exterior and over the gasket causing the heated socket end of the pipe to flow over the gasket and form a retention groove for retaining the gasket before again contacting the working surface of the mandrel. The heated end of the pipe is cooled and retracted from the working surface of the mandrel. The gasket has a special nylon anti-corrosion and anti-friction coating applied to portions of the exterior thereof.